

Work Order ID 50497

July 10, 2009 2:47:43 PM



Page 1

Item ID: D3967-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Rear Overhead, Center

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *NLF*

Date: *09-07-10* Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3967

A-PROTO 09-06-24

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/14 (X1)
M109703

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA060 using tool DT9339
Dwg Rev: *A*
Folio Rev: *A*

BB 09/07/14 (X1)

DART AEROSPACE LTD	Work Order: 50497
Description:	Part Number: D3967-1 REV
Inspection Dwg: D3967-1 Rev: A PROTO	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/07/16

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/- .100	0.25	✓			
0.75"	+/- .100	0.75"	✓			
71.8"	Ref	71.7"	✓			
24.9"	Ref	24.9"	✓			
13.3"	Ref	13.3"	✓			
0.045	MIN	0.053	✓			except indicated area
0.025"	MIN	0.031	✓			

Measured by: D. Heger

Date: 09/07/16

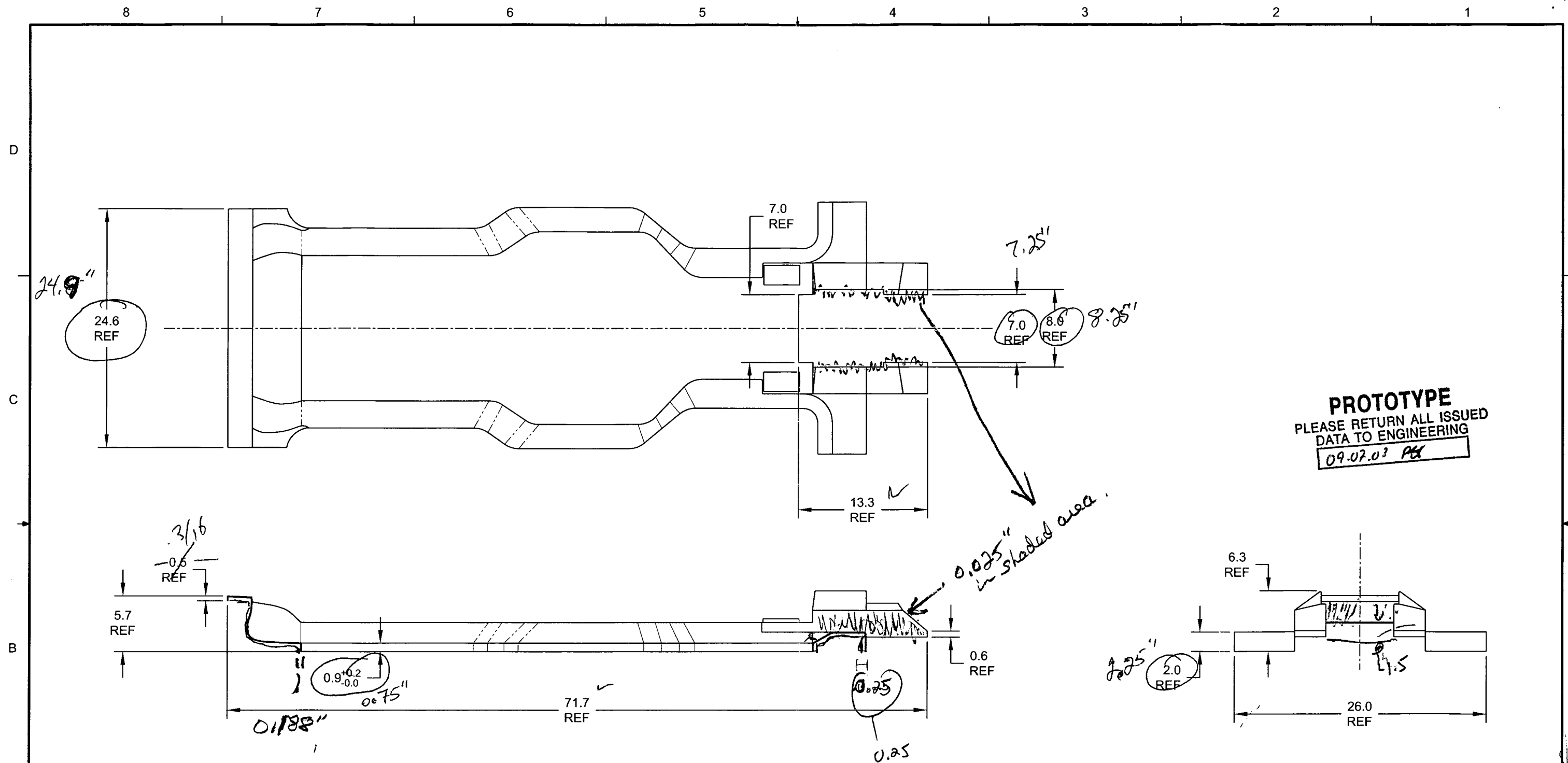
Audited by: RH

Date: 09.07.17

Prototype Approval: RH

Date: 09.02.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3967-1 REAR OVERHEAD CENTER

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.08 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3967-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3967-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

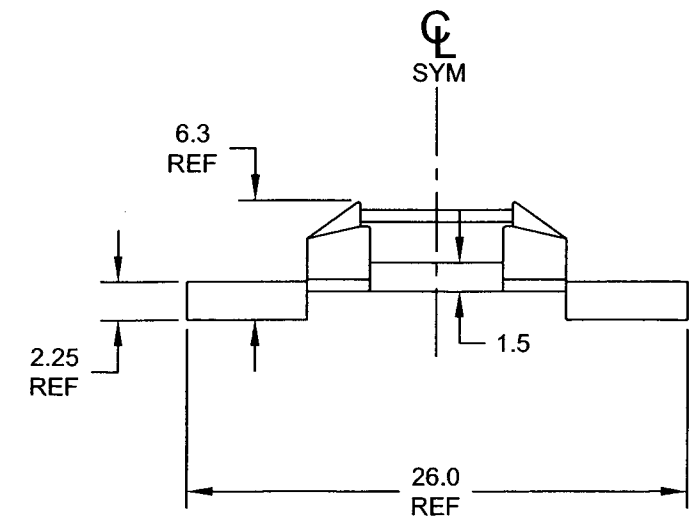
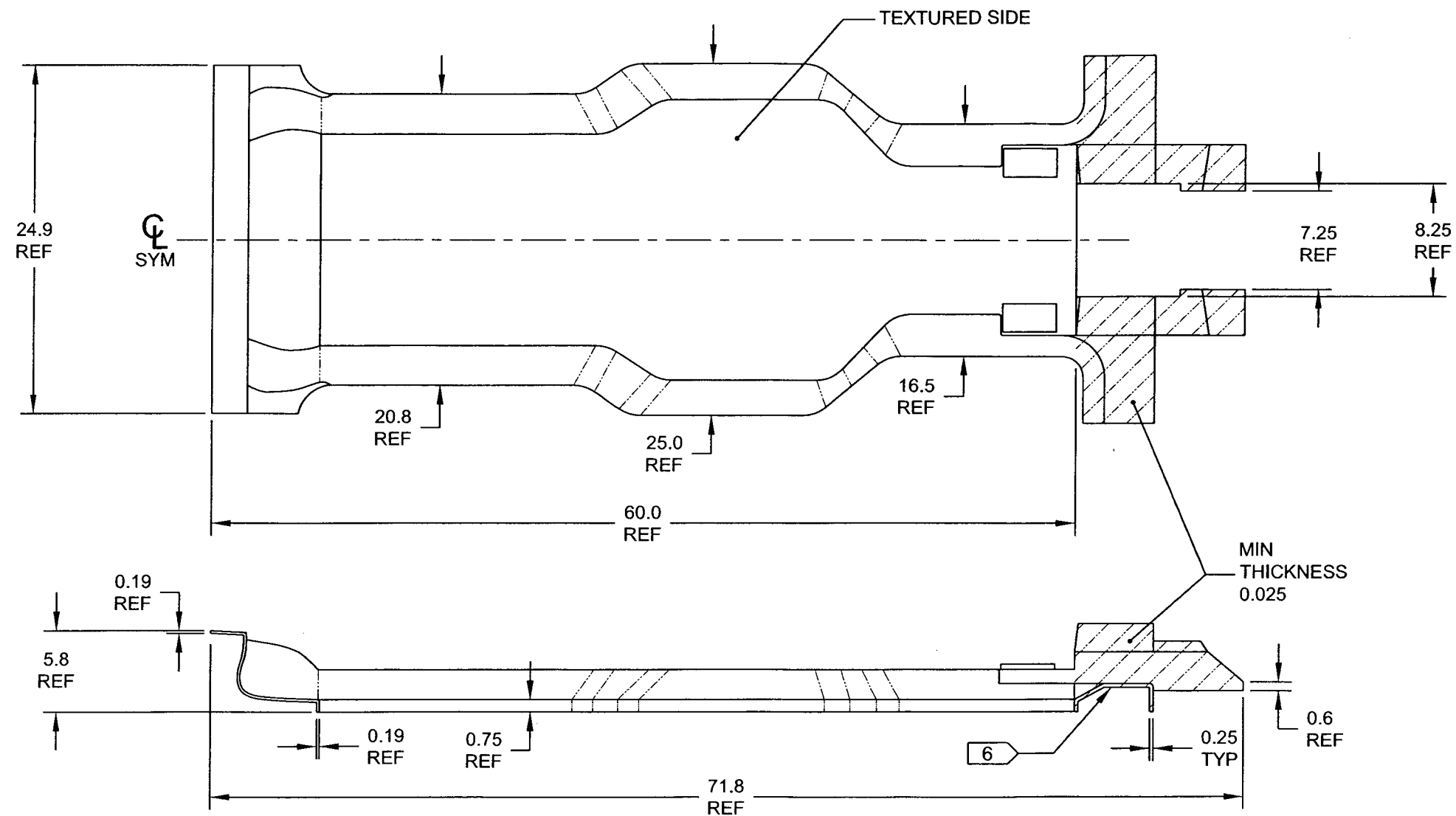
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A D3967 SHEET 2 OF 3
MFG. APPR.		
APPROVED		TITLE SCALE REAR OVERHEAD CENTER (206 L3/L4) NTS
DE APPR.		
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D

C

B

A

**D3967-1 REAR OVERHEAD CENTER****NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9340 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3967-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3967-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE		
CHECKED	W.S.	DRAWING NO.	REV. A
MFG. APPR.	W.S.	D3967	SHEET 1 OF 1
APPROVED	W.S.	TITLE	SCALE
DE APPR.	W.S.	REAR OVERHEAD CENTER (206 L3/L4)	NTS
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